

Work Order ID 72067

Tuesday, July 19, 2011 7:53:26 AM

Page 1

Item ID: D3637-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket Assembly

Start Date: 7/19/2011 Start Qty: 16.00

Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 16.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-11 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3637

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3637 ☐ Dwg Rev: B ☐ Prog Rev: ☐ 2-
Deburr if necessary

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

RUSH*11/07/21**16**11/07/21**16**11 07 21 (16)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____



NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries







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Item ID: D3637-041 Accept  Setup Start 
Revision ID:
Item Name: Bracket Assembly Stop 
Start Date: 7/19/2011 Start Qty: 16.00  Cust Item ID:
Required Date: 7/26/2011 Req'd Qty: 16.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE	0.00							
Brake NC	Memo Form as per Dwg D3637	0.00		SB 1167/21					
140  Small Fab	Small Fab	0.00							
Small Fab	Memo 1- drill holes as per dwg using DT8979 □ 2-C'Sink as per Dwg D3637 □ 3- Install Nut plate as per Dwg D3637	0.00							SB 11/07/22 
150  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							SB 11 07 22 

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Item ID: D3637-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 7/19/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 245

0.00



Packaging

Memo

0.00

Packaging

11/7/228 (16)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/25 (16)11-07-22
(16)

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Picklist Print

Tuesday, July 19, 2011 7:53:31 AM

Page 1

Work Order ID: 72067

Parent Item: D3637-041

Parent Item Name: Bracket Assembly



Start Date: 7/19/2011

Required Date: 7/26/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-3 Rivet		Purchased	No			100	Each	1,995.000	2	32		7/11/07/22	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST316				1995					
					19099			1995					
M304S14GA 304SS sheet .080		Purchased	No			140	sf	50.7000	0.09	1.515789			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT020				50.7					
					113295			18.7					
					117933			32					
MS21059L4 Nutplate		Purchased	No			140	Each	37.0000	1	16		7/11/07/22	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST301				37					
					117887			37					

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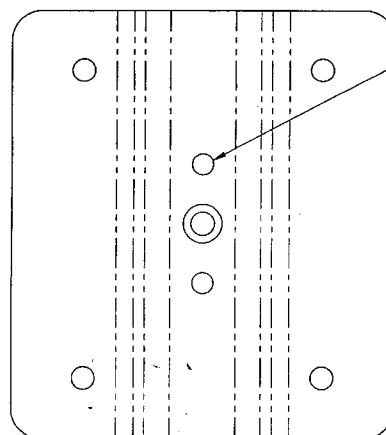
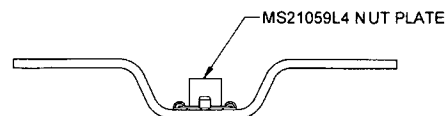
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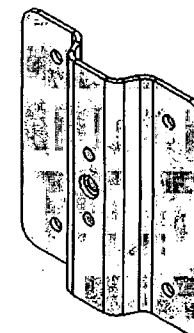


MS20426AD3-3 RIVET
(2 PLACES)

D3637-1 BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72067

PH-07-19



D3637-041 BRACKET ASSEMBLY (WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

B	FOR D3637-1, 1 15 WAS 1 30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LE		
CHECKED	EP		
MFG. APPR.	EP		
APPROVED	EP		
DE APPR.	EP		
DATE	07.12.18		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3637		REV. B SHEET 1 OF 3	
TITLE BRACKET		SCALE 1:1	
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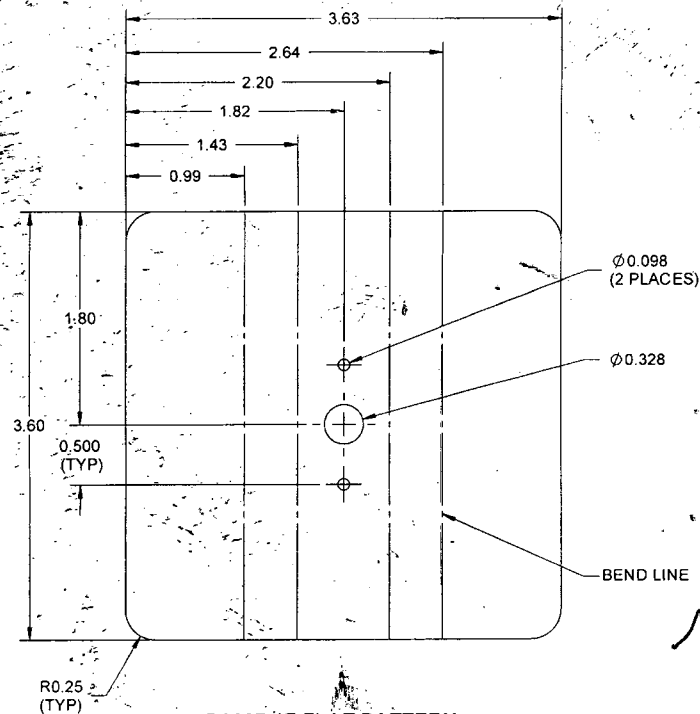
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

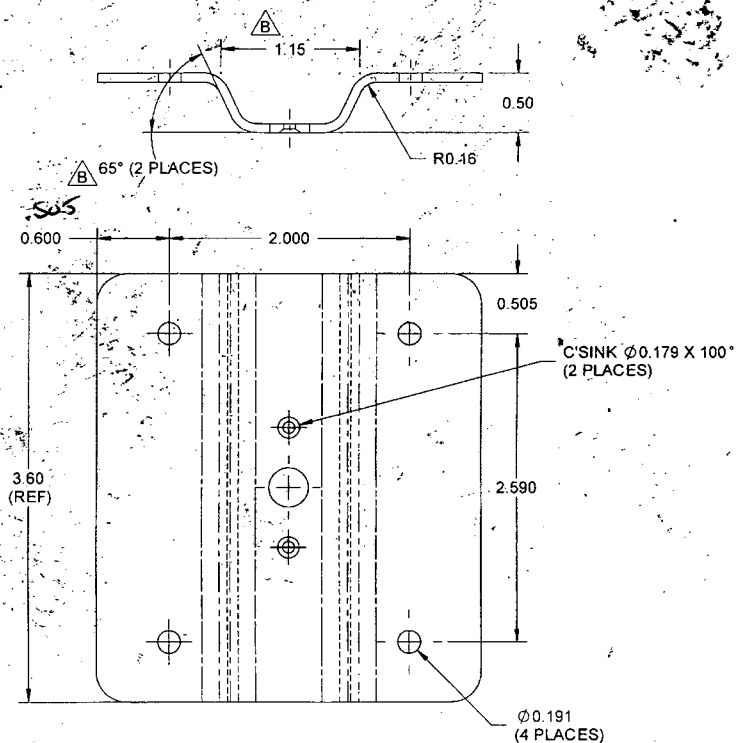
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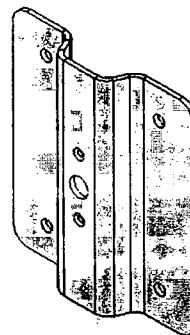
NOTE: Date & initial all entries



D3637-1F FLAT-PATTERN



D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)



D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	ML	D3637	SHEET 2 OF 3
APPROVED	ML	TITLE	SCALE
DE APPR.	ML	BRACKET	1:1
DATE	07.12.18	COPY RIGHT © 2007 BY DART AEROSPACE LTD	
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RELEASED
08-02-05 TAP

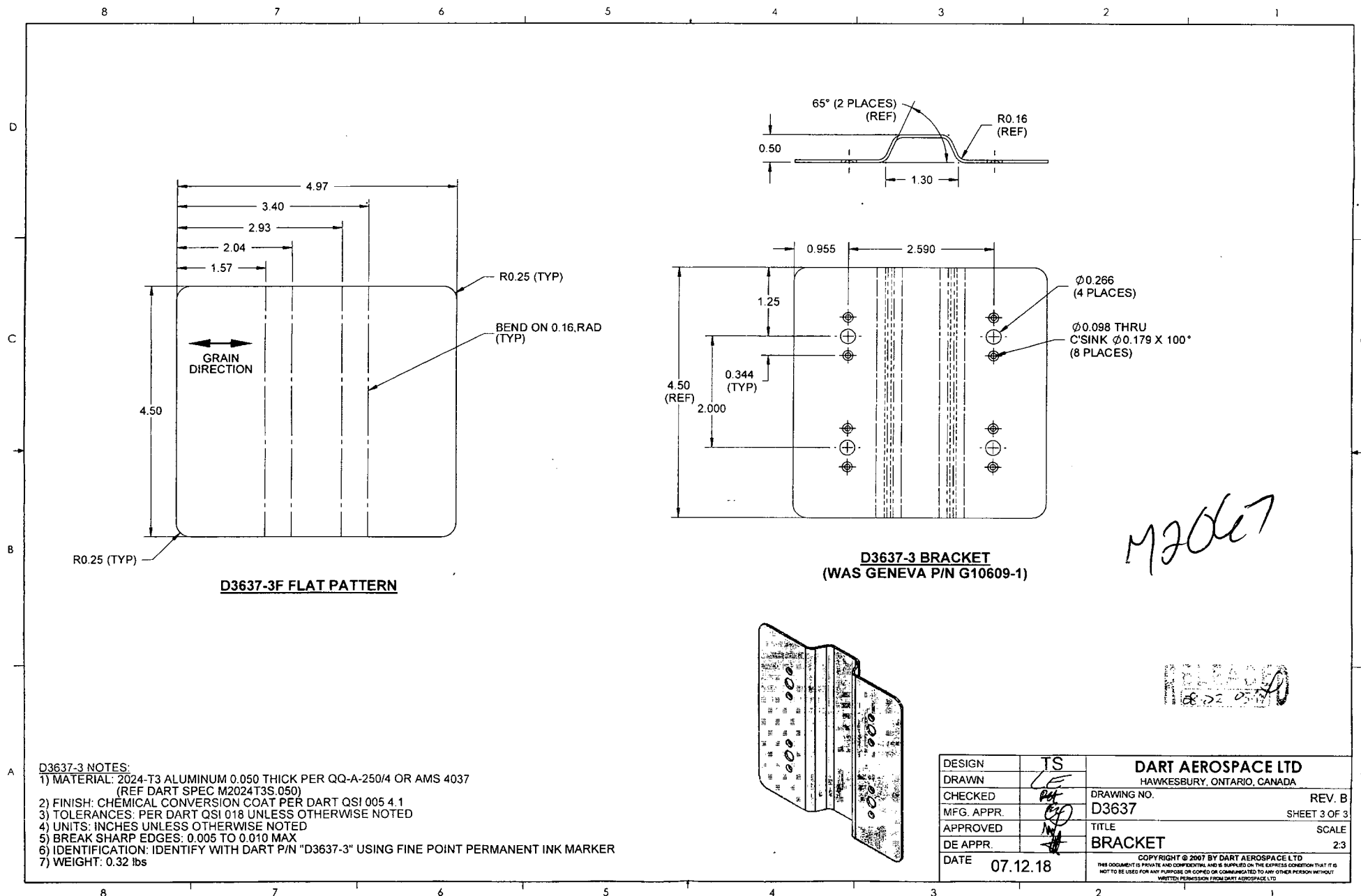
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